

Work Order ID 81758

Friday, March 16, 2012 3:37:41 PM

81758April 4th
Page 1

Item ID: D3914-041 Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Lid Assembly (350)
Start Date: 3/19/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/6/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: mf Date: 12-03-16 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3914	B
D4020	A

100 Weld per dwg A/R S.S. rod Batch: 118366 0.00***1000***

Large Fab

Large Fab

Memo 0.00

1- assemble ribs , weld as per dwg D3914 using DT9607A

2- weld hinge (3) and Mounting brackets as per dwg D3914

Visual inspect before welding mesh

3- tack weld mesh on basket as per dwg D3914

Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo 0.00

PL 12-04-04 1x Ø

PPBE
12-04-04 1 Ø

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81758

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81758



Page 2

Item ID: D3914-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Lid Assembly (350)
Start Date: 3/19/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/6/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC: Inspect dimensions to drawing <i>ALC</i> Memo <i>u</i>	0.00 0.00		<i>5/2/04/04</i>					<i>PTC</i>
130 *130* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo *** mask sides of hinge prior to powdercoat*** Start Time: <i>12h55</i> Oven Temperature: <i>320°F</i> Finish Time: <i>1h25</i>	0.00 0.00		<i>m117 338</i>		<i>1</i>	<i>2</i>	<i>OP</i>	<i>12/04/04</i>
140 *140* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>120902</i> Memo 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***	0.00 0.00				<i>1</i>		<i>BK 12-4-4</i>	

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W/O: 81758		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12.04.04	120	permanent change		12.04.04		 12.04.04	

Part No: D3914-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 4/6/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
160									
Packaging	Memo <u>W/O 81754</u>	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

Handwritten notes and signatures:
- Under 150: 1 0 12/04/04
- Under 160: EP 12/04/04 ①
- Under 170: 12/4/15 MF
- Bottom right: MF 12-04-04

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Friday, March 16, 2012 3:37:40 PM

Page 1

Work Order ID: 81758

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 3/19/2012

Required Date: 4/6/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
10.08.18 verified by:EC

IPP Rev:B as per dwg revB DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581 Mounting Bracket		Manufactured	No			100	Each	23.0000	2	SAD		12-03-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		23							
				69739		1							
				70766		2							
				77045		1							
				77523		19							
D3914-1 Rib		Manufactured	No			100	Each	0.0000	2	B81253 (2)		SAD 12-02-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		2							
				WA006		-2							
D3914-7 Rib		Manufactured	No			100	Each	12.0000	2	B81210 (2)		SAD 12-03-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		12							
				80164		2							
				81208		10							
D4016-3 Hinge Half, Lid		Manufactured	No			100	Each	15.0000	3	(2)		PL12-04-03	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		15							
				78495		15							
D4018-5 Rib		Manufactured	No			100	Each	36.0000	9	B81389 → (3)		SAD 12-03-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		36							
				78041		35							
				80597		1							
										B80776 (9)			

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 2

Work Order ID: 81758

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 3/19/2012

Required Date: 4/6/2012

Start Qty: 1.00

Required Qty: 1.00

D4020-5 Manufactured No
Mesh (350 Basket Long; Lid)

100 Each 5.0000

1

CPC
SAD 12-02-30

Location

Loc Qty

Loc Code

WA

5

B81446

78698

1

81180

4

71182

D4021-3 Manufactured No
Data Plate

100 Each 2.0000

1

SAD 12-02-30

Location

Loc Qty

Loc Code

WA005

2

75460

2

81182

D4035-041 Manufactured No
Lid Rib Assembly, Fwd (350 Basket)

100 Each 2.0000

1

SAD 12-02-30

Location

Loc Qty

Loc Code

WA006

2

74642

2

B74642

D4035-043 Manufactured No
Lid Rib Assembly, Aft (350 Basket)

100 Each 6.0000

1

SAD 12-02-30

Location

Loc Qty

Loc Code

WA006

6

81201

6

B81452

D2728-3 Manufactured No
Dart Logo label

140 Each 0.0000

1

2/04/04

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

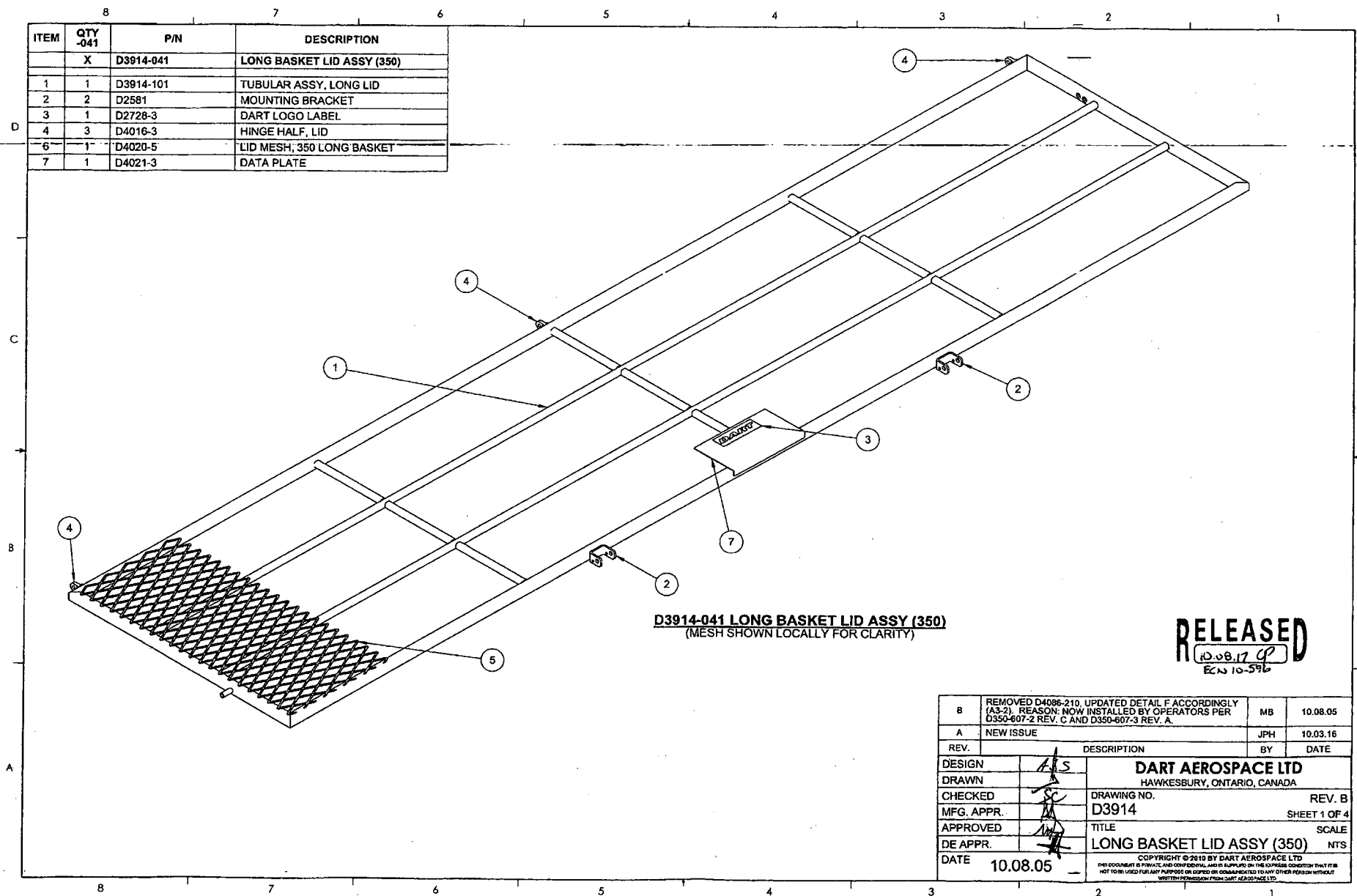
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH; 350 LONG BASKET
7	1	D4021-3	DATA PLATE



RELEASED
10.08.17
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D3914	SHEET 1 OF 4
APPROVED	MB	TITLE	SCALE
DE APPR.	MB	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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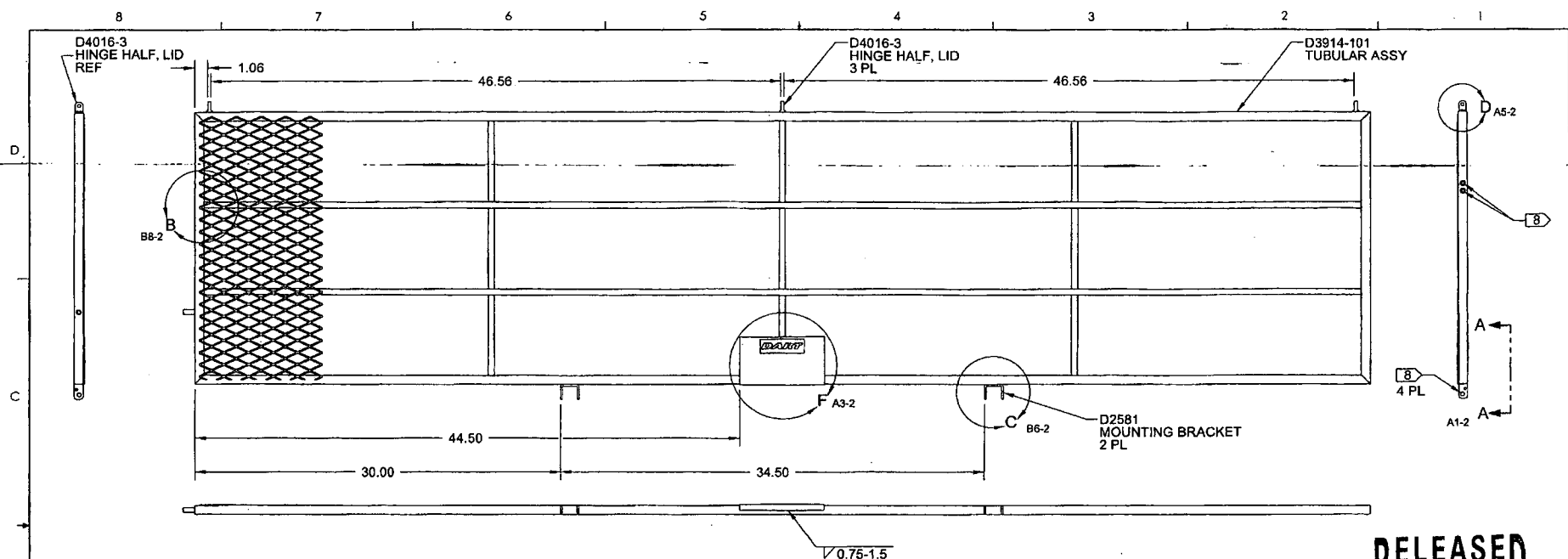
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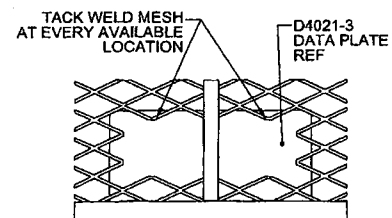
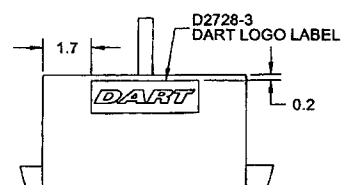
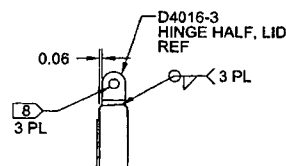
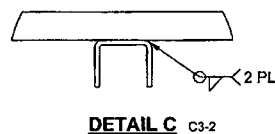
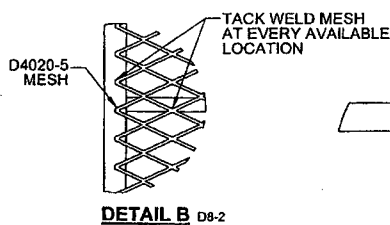
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NOTE: Date & initial all entries



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. B
CHECKED	SC	D3914	SHEET 2 OF 4
MFG. APPR.	MS	TITLE	SCALE
APPROVED	MS	LONG BASKET LID ASSY (350)	NTS
DE APPR.	MS		
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RELEASED
10.08.12 CP

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

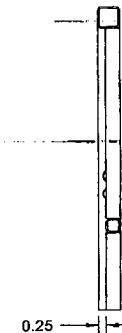
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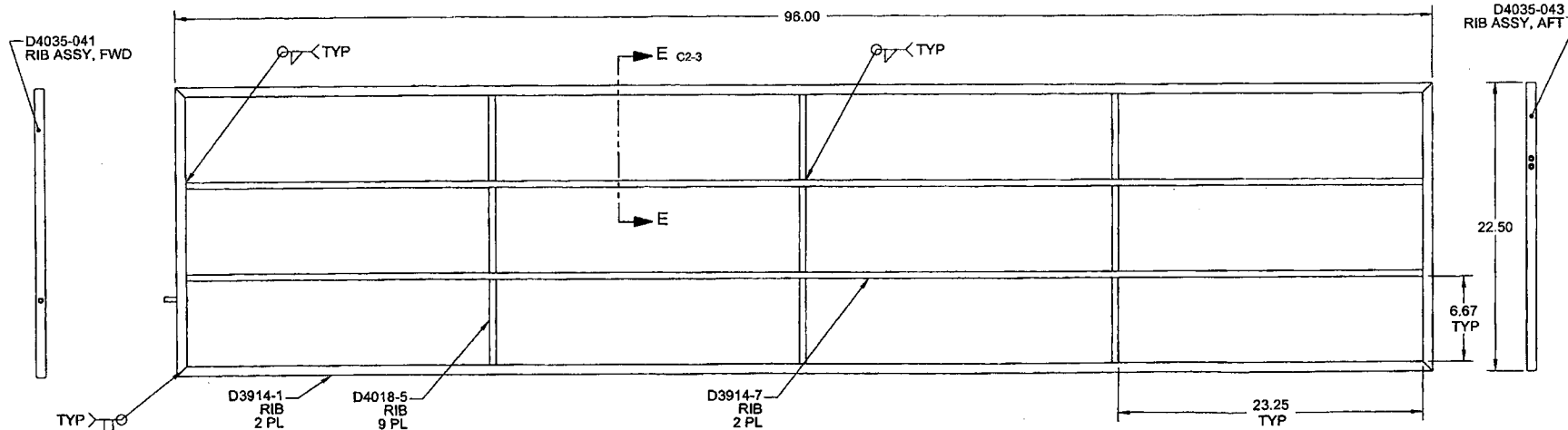
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NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-05

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

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DRAWN	ALS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. B
MFG. APPR.	ALS	D3914	SHEET 3 OF 4
APPROVED	ALS	TITLE	SCALE
DE APPR.	ALS	LONG BASKET LID ASSY (350)	NTS
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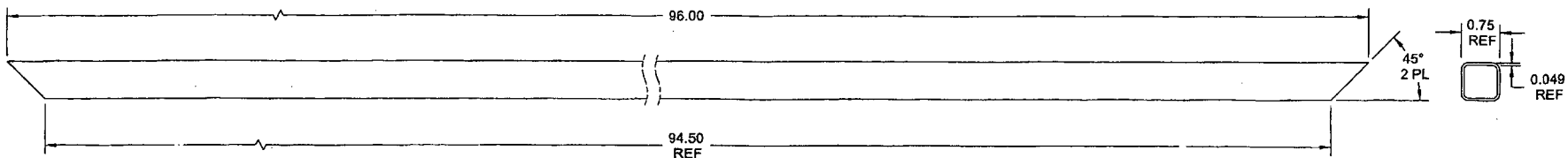
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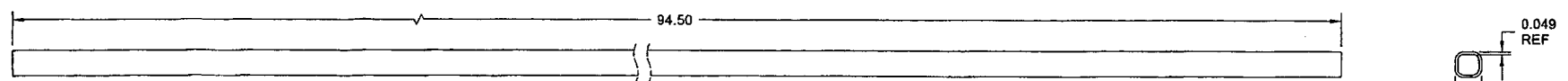
8 7 6 5 4 3 2 1

D



D3914-1 RIB

C



D3914-7 RIB

B

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

A

RELEASED
10.08.12

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO. D3914	REV. B
MFG. APPR.	SC	SHEET 4 OF 4	
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8 7 6 5 4 3 2 1